

628-03

Date: Friday, 1/25/2008 10:48:59 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	206B FLOAT STEP ASSY, LH
Job Number	36963A			
Estimate Number	11662			
P.O. Number			Part Number	D2841041
This Issue	1/25/2008	S.O. No. :	Drawing Number	D2841 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	11	Type :	Drawing Revision	B
Previous Run	36078A		Material	
Written By		1080125	Due Date	3/10/2008
Checked & Approved By			Qty:	4
Comment	Est Rev.D	As Per Ecn 766 06-01-06 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)	
Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B36923</u>
Check Material for any Dents or Defects			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment:	LARGE FABRICATION RESOURCE 1		
1-Cut D2841-1 using D2622 extrusion as per Dwg D2841			<u>CAD 08/03/18</u>
2-Drill extrusion per drawing D2841 using Jig DT 8265			<u>08-03-18</u>
3-Deburr and bevel ends for welding			<u>08-03-18</u>
3.0	QC6	DIMENSIONAL CHECK	
Comment:	DIMENSIONAL CHECK		<u>S 08/03/19</u>
4.0	D2734	206 Step Endplate	
Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 8.0000 Each(s)	
206 Step Endplate			
Pick:			
Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>336520</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36963A

Part Number: D2841041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34641 mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
1	D3464-1	Plate	325425

4

6.0 D34643 mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-3	Plate	325426

4

7.0 D34645 mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-5	Plate	325427

4

8.0 D34647 mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-7	Plate	325428

4

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

4

1-Weld end cap(AFT END ONLY) and lugs as per Dwg D2841
using Jig DT 8267 followed by DT 8268

A/R AL ROD Batch: M106734
M106762

4

2-Grind end cap welds flush

4

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D2841041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08-03-27 ①

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/27(44)

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6 08/03/28(44)44

14.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

PL 08-04-01

2-Weld Remaining end cap as per Dwg D2841

PL 08-04-01

Grind →
A/R AL ROD Batch: M106834

4

4

PTO

15.0 QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-03-01

08/04/02

④ CH

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/04/02

④ CH

17.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine & Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

PL 08-04-02

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-04-02	14b.	grind end caps flush as per drawing 2841	16	08-04-02	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number:



Seq. #: Machine Or Operation:

Description :

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



F1 08/04/03 (4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0 NAS1329C3KB130 insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch
4 NAS1329C3KB130 Insert m106951

F1

20.0 MS27039C107 screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 MS27039C1-07 Screw m107008

F1

21.0 NAS1515H3L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 NAS1515H3L WASHER m106516

F1

22.0 AN960C10L washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN960C10L WASHER m107008

F1

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m107385

F1 08/04/03 (4)

W/O:		WORK ORDER CHANGES					
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Part Number: D2841041

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 QC5 INSPECT WORK TO CURRENT STEP



8/04/07

Comment: INSPECT WORK TO CURRENT STEP

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Rev F

8/04/07

(X4)

26.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/08
OK

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-07

W

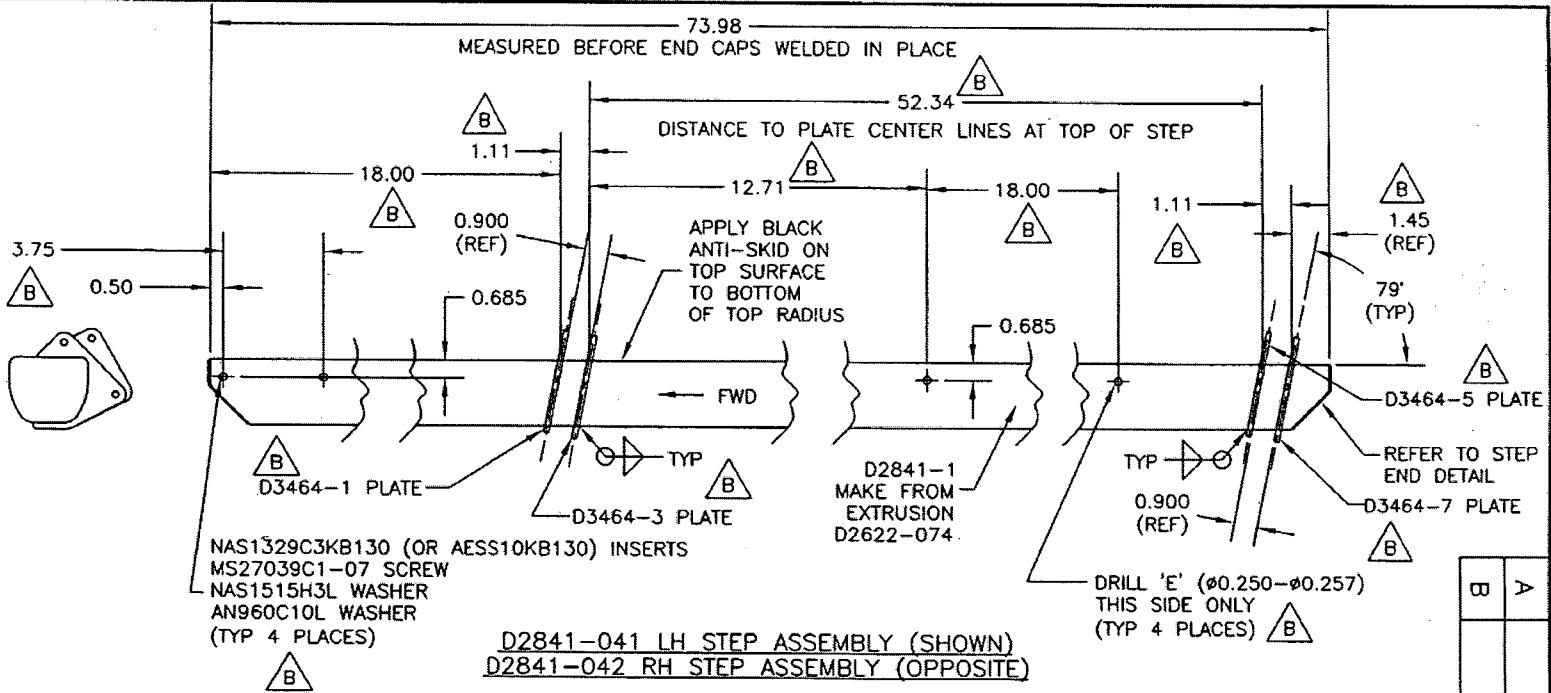
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART



D2841-041 LH STEP ASSEMBLY (SHOWN)
D2841-042 RH STEP ASSEMBLY (OPPOSITE)

D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2841-041	LH STEP ASSEMBLY
X		D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2841-041/-042 STEP ASSEMBLY

MAKE FROM EXTRUSION D2622

WELD PER DART QSI 004

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

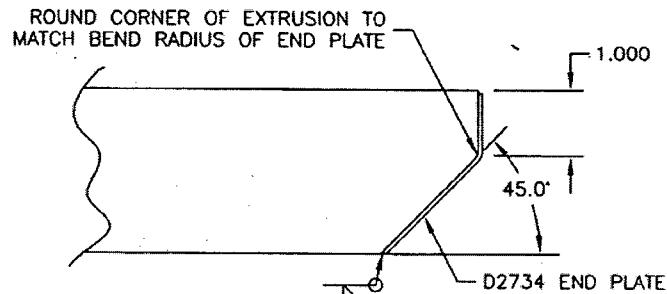
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

ALL DIMENSIONS ARE IN INCHES

ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14



TYPICAL STEP END DETAIL
NOT TO SCALE

RETURN TO
ENGINEERING
FOR
CONTROLED COPY
SUBJECT TO AMENDMENT
NOTICE
WITHOUT NOTICE
NO. 36963A
WORK ORDER

DESIGN KE	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE		DRAWING NO.	REV. B
A	PH	98.10.14	NEW ISSUE
B	CH	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7
DATE		TITLE	
05.09.21		206B FLOAT STEP ASSEMBLY	
APPROVED		D2841	SHEET 1 OF 1
RE-DESIGN, ADD D2843-1/-3/-5/-7			SCALE
			NTS